

Date: Thursday, 10/04/2008 4:00:53 PM
 User: Julie Lecocq

Process Sheet

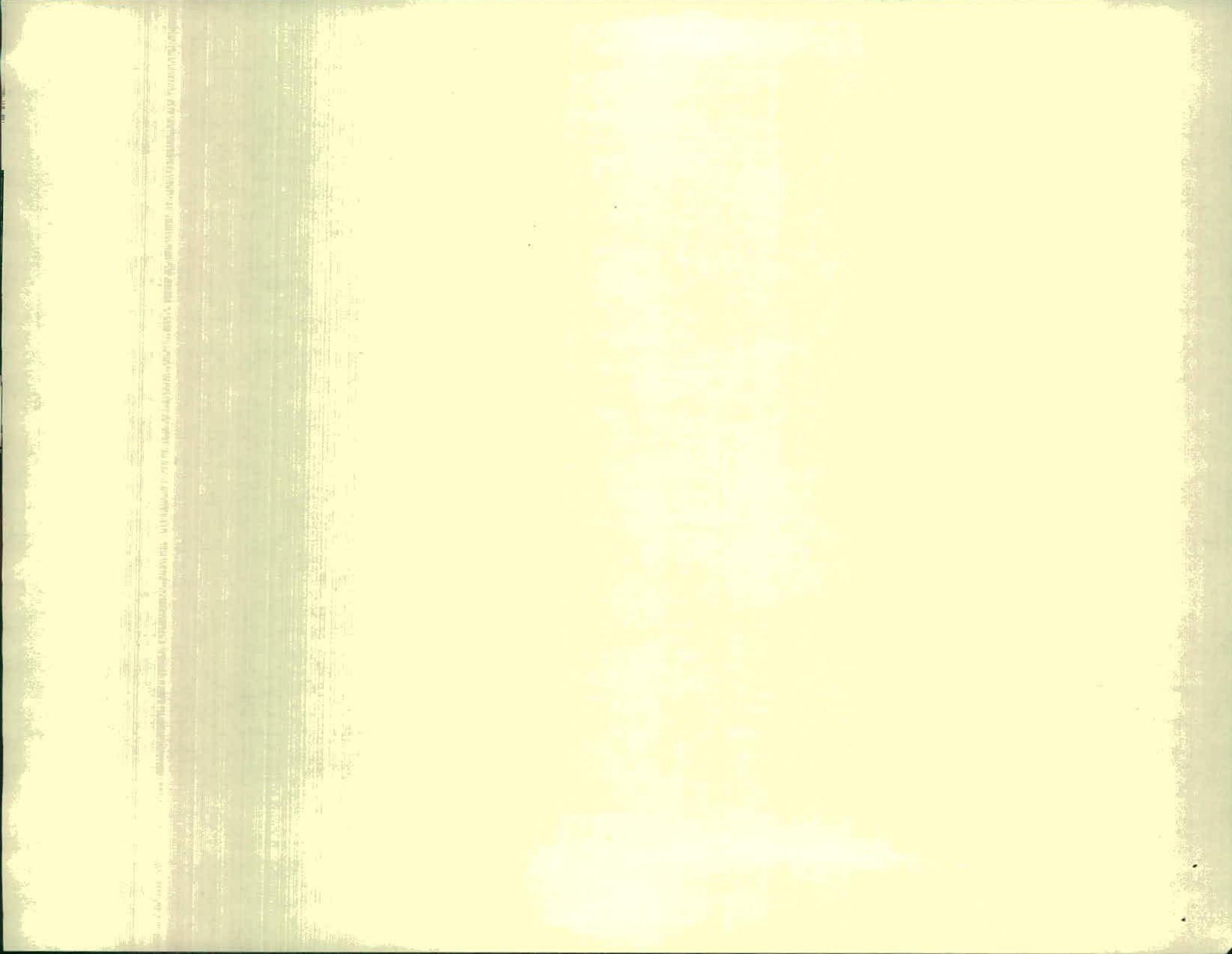
Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	WEARPAD		
Job Number	38548			Part Number	D356411		
Estimate Number	12785			Drawing Number	D3564 REV'D		
P.O. Number				Project Number	N/A		
This Issue	10/04/2008	S.O. No.		Drawing Revision	D		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	SMALL /MED FAB	Due Date	30/04/2008		
Previous Run	37811			Qty:	30	Um:	Each
Written By							
Checked & Approved By	<u>JB 08.4.10</u>						
Comment	Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	48.
Comment: Qty.: 1.48050 sf(s)/Unit Total: 44.41500 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <u>101676</u> IB 8-4-14		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3564 ****(D3564-1F)**** Dwg Rev: <u>D</u> 32 Prog Rev: <u>D</u> IB 8-4-14		
2-Deburr if necessary IB 8-4-14		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE 8-8-4-14		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK 8-8-4-14 32		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT and DT 8179 8155		



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Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

✓ 08/04/17 +32

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty	Description	Batch
A/R	2059B Hardcoat	11166115
Weld hardcoat as per Dwg D3437		

08-04-29 SP 6X

8.0 QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

✓ 08/04/29 6X

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0 POWDER COATING

POWDER COATING



B38548
D356411
30/04/2008

S.156 08.27
#1 318.7 F
#2 777.5 F
#3 70- F
#4 ----- F

11105442

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

✓ 08-04-30

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

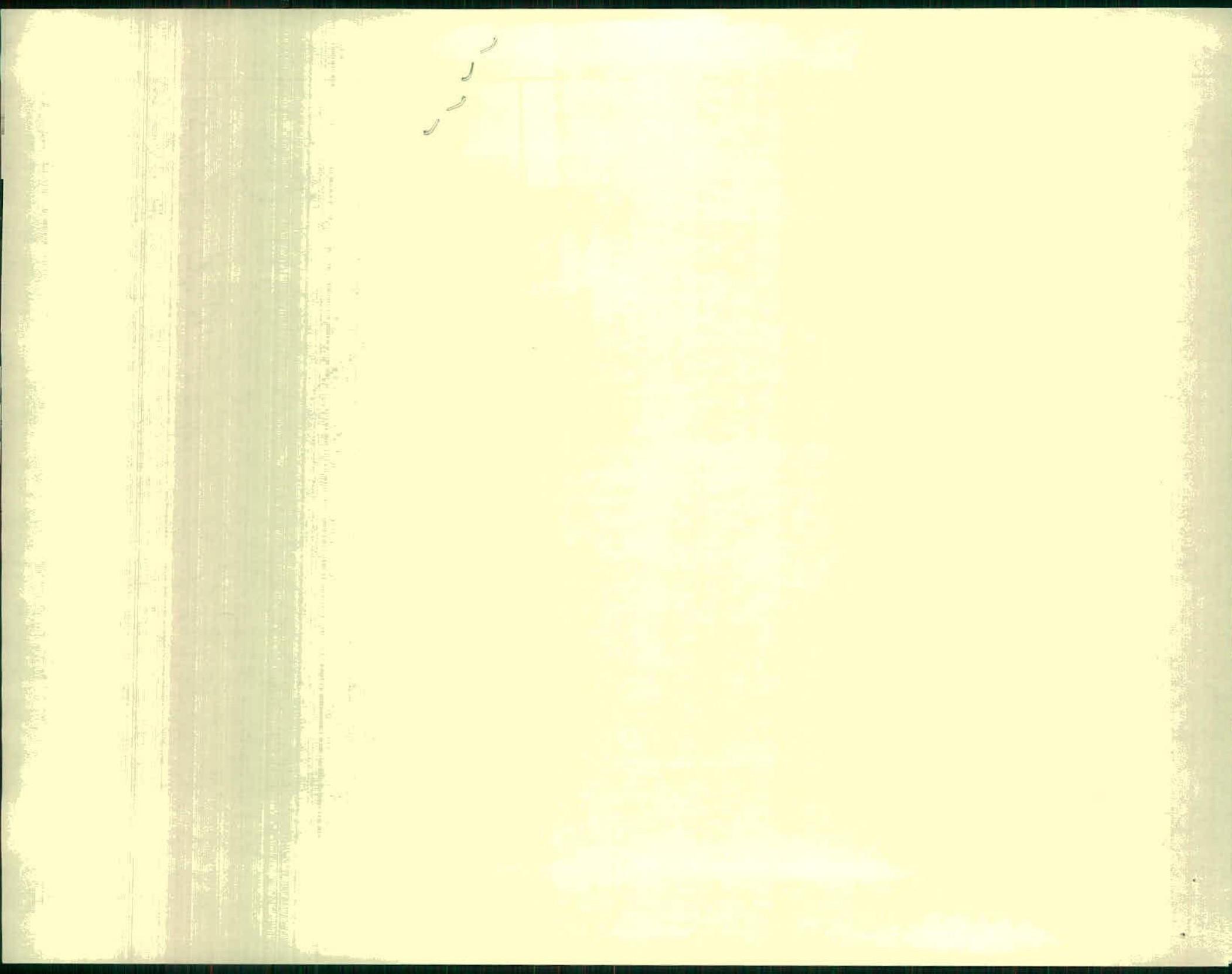
Location: _____

F-P-18

m-f 08/04/30

6X

m-f 08-04-30



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Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC21

FINAL INSPECTION/W/O RELEASE



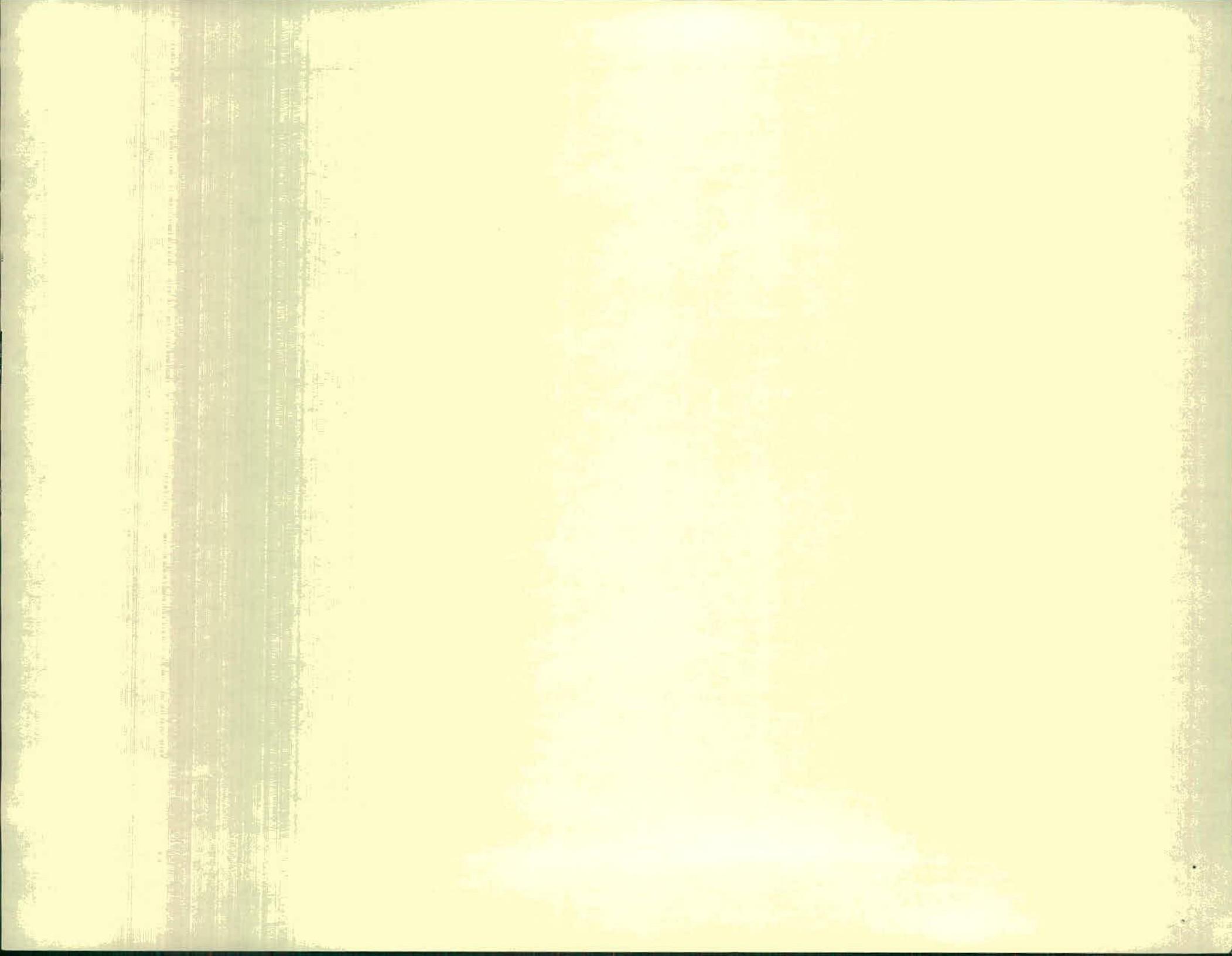
08/05/01 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



See previous sheet



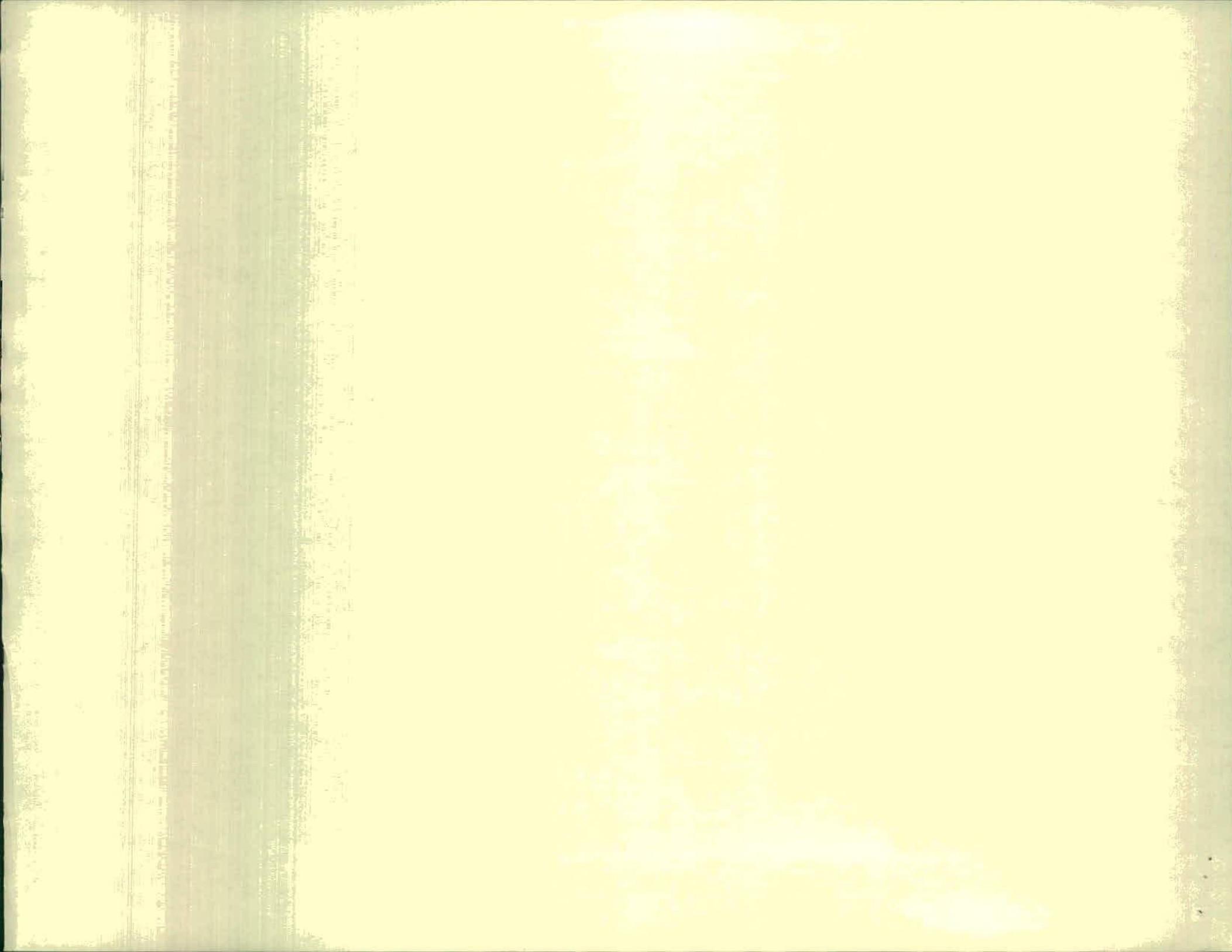
DART AEROSPACE LTD	Work Order:	38548
Description: Wearshoe	Part Number:	D3564-11
Inspection Dwg: D3564	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

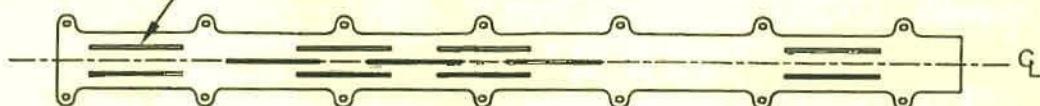
X First Article Prototype

Measured by:	IB	Audited by:	S	Prototype Approval:	N/A
Date:	8-4-14	Date:	8860415	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	07.11.23	Dwg Rev updated	KJ/EC/DD	



2059B HARDCOAT WELD 4.0 LONG 0.063 TO 0.125 HIGH
(11 PLACES)
WELD AFTER BENDING AS ILLUSTRATED PER DT8308



DETAIL D

(D3564-1/3-9/11 WELDING DETAIL)



DETAIL B

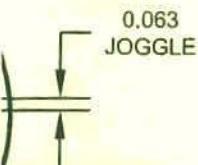
RELEASED

07-09-04



R2.00

SECTION C-C
SCALE 1:1



DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	SI	D3564	SHEET 3 OF 3
APPROVED	10	TITLE	SCALE
DE APPR.	-	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

